

CLAIMS AMENDMENTS

1. (currently amended) Process for producing cigarette packs (10) of the hinge-lid type with an outer wrapper made of film and with a tear-open strip (12) applied to the outer wrapper, characterized by comprising the following steps of:
 - a) attaching the tear open strips (12) to drawing a continuous film web (13) off of a reel (15),
 - b) severing blanks (11) for the outer wrapper from the continuous film web (13),
 - c) drawing a material strip (18) for producing the tear-open strip (12) is provided with off of a separate strip reel (19), the material strip (18) having precisely positioned printing or markings (24) thereon, and feeding the material strip (18) to the continuous film web (13),
 - d) applying the material strip (18) to the continuous film web (13),
 - e) sensing the printing or markings (24) on the material strip (18) for producing of the tear-open strip (12) are sensed by a print-mark reader (26) after the material strip (18) for producing the tear-open strip (12) has been attached applied to the film web (13), and then
 - e) severing blanks (11) for the outer wrapper from the continuous film web (13) to which the material strip (18) has been applied, wherein a severing cut for severing the blanks (11) with the tear-open strips (12) from the continuous film web (13) is controlled in accordance with the detected printing or markings (24) of the tear-open strip (12).

2. (currently amended) Process according to Claim 1, characterized in thatwherein the film web (13) ~~(also) has printing, markings, further comprises printed marks (25)-or the-like, and in that said printing, printed marks (25), etc. are sensed by sensors-printed-mark readers (30)—preferably by separate printed-mark readers (30) assigned to said printing or printed marks (25) of the film web (13).~~
3. (currently amended) Process according to Claim 1, characterized in thatwherein the printing, ~~or~~ markings (24) and/or printed marks (25) sensed by the sensors or printed-mark readers (26-30) are evaluated for the purpose of controlling the drive of the film web (13) and/or of the material strip (18).
4. (cancelled).
5. (cancelled).

6. (currently amended) Apparatus for producing cigarette packs (10) of the hinge-lid type, with an outer wrapper made of film and with a tear-open strip (12) applied to the outer wrapper and likewise consisting of film, in which blanks (11) for the outer wrapper are severed from a continuous film web (13) that has a tear-open strip (12) applied thereto, characterized by the following features comprising:

- a) a strip reel (19) containing the a material strip (18) for producing the tear-open strips (12), the material strip (18) is provided with having precisely positioned printing or markings (24) thereon, the material strip (18) being held ready on the strip reel (19) for being drawn off along a path of movement,
- b) a reel (15) containing the continuous film web (13), the continuous film web (13) being held ready on the reel (15) for being drawn off along the path of movement,
- c) a means for applying the material strip (18) to the continuous film web (13) along the path of movement,
- d) a printed-mark reader (26) located in the region of the path of movement of along which the material strip (18) for producing the tear-open strips (12) connected is applied to the film web (13), the film web (13) is assigned a wherein the printed-mark reader (26) for the purpose of sensing senses the printing or markings (24) of the material strip (18) for producing the tear-open strips (12),
- e) the printed-mark reader (26) is connected to an evaluation unit, connected to the printed-mark reader (26), for evaluating the detected positions of the printing or markings (24) on the material strip (18) for producing the tear-open strip (12) sensed by the printed-mark reader,
- f) a means for severing the blank (11) containing the tear-open strip (12) from the continuous film web (13) to which the material strip (18) has been applied, and
- g) drive elements for the continuous film web (13), whereby the drive elements are controlled by the printed-mark reader (26) via the evaluation unit.

7. (currently amended) Apparatus according to Claim 6, characterized in that further comprising at least two sensors—printed-mark readers (26, 30)—are provided for the purpose of sensing printing, or markings (24), printed marks (25), etc. both of the material strip (18), or of the tear-open strips (12), and of the film web (13), printing, printed marks (25), etc. of the film web (13) being positioned in an offset manner in relation to the material strip (18) or to the tear-open strips (12).

8. (currently amended) Apparatus according to Claim 6, characterized in that further comprising conveying elements for the material strip (18) and/or the film web (13) provided with material strip (18) and/or tear-open strip (12), wherein the conveying elements can be controlled by the sensors—printed-mark readers (26, 30)—in respect of changing the drive speed of the film web (13) and/or material strip (18).

9. (currently amended) Apparatus according to Claim 8, characterized in that further comprising conveying rollers (31, 37) and/or drive-rollers (28, 31, 37) assigned to for driving the film web (13) and/or the material strip (18) can be, wherein the rollers are driven by controllable servomotors (29, 33), it being possible for and the servomotors (29, 33) to be controlled by the printed-mark readers (26, 30).

10. (currently amended) Apparatus according to Claim 9, characterized by the following features wherein:

- a) a controllable drive roller one of the rollers (28) is arranged located in the region of the film web (13), and is provided with tear-open strip (12) or material strip (18), preferably immediately upstream of a blank station (14),
- b) a further controllable drive roller another of the rollers (31) is positioned in the region of the material strip (18), and
- c) the two drive elements—drive roller (28) and conveying roller (31, 37)—can be rollers (28, 31) are controlled by sensors—the printed-mark readers (26, 30)—assigned to the tear-open strips (12) or the material strip (18), on the one hand, and to the film web (13), on the other hand.

11. (currently amended) Apparatus according to Claim 10, characterized in that a controllable conveying roller a third of the rollers (37) for the material strip (18) is positioned adjacent to a severing subassembly for severing tear-open strips (12) from the material strip (18), in particular adjacent to a cutter roller (36).

12. (cancelled).

13. (cancelled).

14. (cancelled).

15. (cancelled).

16. (currently amended) Apparatus according to Claim 1, further comprising two Reel reels for the material strips (18) for the production of a the tear-open strip (12) to be attached to a blank (11), and a common reel core (63), with wherein the material strip (18) is drawn off of both of the reels and is laid on a the film web (13) and it being possible to sever the blanks (11) with tear-open strip (12) are severed from the latter film web (13), characterized in that in order to feed two material strips (18) to one film web (13) (each) the two material strips (18) are wound on a common carrier, in particular on a common reel shell or on a common reel core (63).

17. (currently amended) Reel according to Claim 16, characterized in that wherein the two single-reels (46, 47) are wound on the common reel core (63) at a slight distance from one another, preferably with a matching winding structure.

18. (currently amended) Reel according to Claim 16, characterized in that wherein two immediately adjacent, parallel material strips (18) can be wound on a single, common strip reel (45) and can be drawn off together as a unit.

19. (currently amended) Process according to Claim 2, characterized in that ~~wherein~~ the printing, or markings (24) and/or printed marks (25) sensed by the sensors of printed-mark readers (26, 30) are evaluated for the purpose of controlling the drive of the film web (13) and/or of the material strip (18).

20. (cancelled).

21. (currently amended) A process for producing cigarette packs (10) of the hinge-lid type with an outer wrapper made of film, comprising the steps of:

- a) providing a material strip (18) with precisely positioned printing or markings (24) and for producing tear-open strips (12) with the precisely positioned printing or markings (24) thereon;
- b) attaching the tear-open strips (12) with having the precisely positioned printing or markings (24) thereon to a continuous film web (13) from which individual blanks (11) for the outer wrapper comprising the tear-open strips (12) are produced;
- c) sensing the printing or markings (24) of the tear-open strips (12) with a print printed-mark reader (26);
- d) controlling the positioning of a severing cut for severing the individual blanks (11) comprising the tear-open strips (12) from the continuous film web (13) in accordance with the sensing of the printing or markings (24) of the tear-open strips (12); and then
- e) severing the individual blanks (11) for the use as an outer wrapper from the continuous film web (13) based on the sensing of the printing or markings (24) of the tear-open strips (12), wherein the blanks (11) comprise a portion of the continuous film web (13) and the tear-open strip (12) and whereby the printing or markings (24) of the tear-open strips (12) are positioned in a precise position relative to the blank (11).

22. (currently amended) An apparatus for producing cigarette packs (10) of the hinge-lid type with an outer wrapper made of film, comprising:

- a) means for providing a material strip (18) with precisely positioned printing or markings (24) and thereon for producing tear-open strips (12) with ~~the precisely positioned printing or markings (24) thereon~~;
- b) means for attaching applying the tear-open strips (12) with having the precisely positioned printing or markings (24) thereon to a continuous film web (13) from ~~which individual blanks (11) for the outer wrapper comprising the tear-open strips (12) are produced~~;
- c) a printed-mark reader (26), located proximal to a path of movement where the tear-open strips (12) are attached applied to the film web (13), for sensing the positions of the printing or markings (24) ~~ef on~~ the tear-open strips (12);
- c) an evaluation unit, connected to the printed-mark reader (26), for evaluating the sensed positions of the printing or markings (24) on the tear-open strip (12); and
- d) drive elements, which are controlled by the printed-mark reader (26) via the evaluation unit, for driving the continuous film web (13) so as to allow the severing of the individual blanks (11) for the outer wrapper from the continuous film web (13) at a position based on the sensing of the printing or markings (24) ~~ef on~~ the tear-open strips (12) whereby the printing or markings (24) of the tear-open strips (12) are positioned in a precise position relative to the blank (11).

23. (new) Process according to Claim 2, characterized in that the printed marks (25) are evaluated for the purpose of controlling the drive of the film web (13).